

538

DART AEROSPACE LTD.		Work Order:	24126
Description: Saddle Fitting, Aft (Outboard/Inboard)		Part Number:	D2573/D2574
Drawing: D2573 Rev. D/D2574 Rev. D		Qty:	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	AS	05/08/80	12
2	MV	Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B21802 B21818	JL	05.08.18	12
3	MV	Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B21817A	JL	05.08.18	12
4	MV	Fixturing W/O No. Fixturing Inspection last completed by 05.09.07		N/A	
5	MV	Program Batch No. 24126 Double check by: E	JL	05.09.13	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	JL	05/09/18	12
9	MV	Machine keyway as per dwg D2573 & D2574	JL	05/09/18	12
10	MV	Deburr and remove all machining marks	JL	05/09/18	12
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	JL	05/09/12	12
12	QC1	Inspect all dimensions to dimension sheets	JL	05/09/18	12
13	QC7	Second inspection	ML	05/09/19	12
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	05 09 22	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	FL	05 09 23	12
16	QC3	Inspect Powder Coat	ML	05 09 23	12
17	ST	Identify and Stock.	CL	05/09/26	12
18	AC	Cost / Part 150.30 113.38	SAC	05.09.29	12
19	DC	Close W/O 151.62 114.95 Inspection Level 21	DP	05/09/27	12

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ RF	

RELEASED
02/10/15 RF